

Date: Wednesday, 6/21/2006 7:23:37 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKIDTUBE "I" BEAM
 Job Number : 27655
 Estimate Number : 10346
 P.O. Number : N/A Part Number : D2596
 This Issue : 6/21/2006 S.O. No. : N/A Drawing Number : D2596 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C
 Previous Run : 27426 Material : N/A
 Due Date : 6/28/2006 Qty: 20 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : LA
 Comment : Est: D-99.02:02 Changed QA to QC, Added Step 6 and Cost D
 M

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Ext'n -I' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick;

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D2500-3-100 | Extrusion | B25751 |

Batch

Pm '06-06-27 (20)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Cut D2500-3-100 to length: 99.5"

2- Use Jig DT8093 to drill pilot holes #30

3- Open to 0.625" diameter using a uni-bit

4- Deburr

Pm '06-06-27 (20)

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

M.F. 06/06/27 (20)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP

06-6-27

(20)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 26

DP 06-6-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 20/06/27

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 6/21/2006 7:23:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 27655

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06/26/27 (20)

Job Completion



U 06-06-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

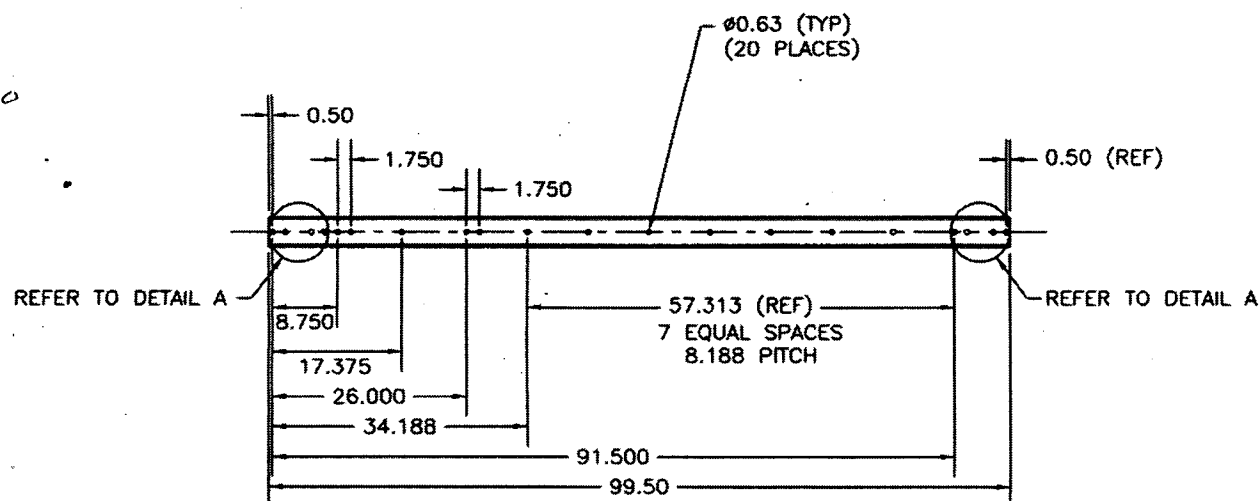
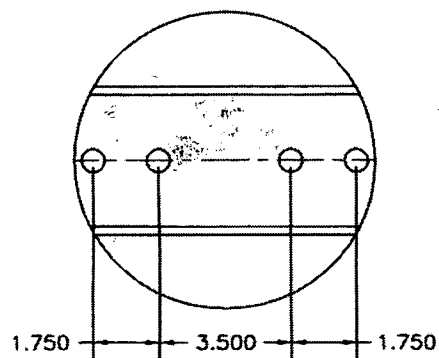
DART



RELEASED
98.09.17 DS

| | | | |
|------------------|------------------|---|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HANKESBURY, ONTARIO, CANADA | REV. C |
| CHECKED | APPROVED | DRAWING NO. D2596 | SHEET 1 OF 1 |
| DATE 98.09.14 | TITLE 205 WEB | SCALE 1:24 | |
| A | 96.09.16 | NEW ISSUE | |
| B | 97.07.23 | Ø0.63 HOLE WAS Ø0.56 | |
| C | 98.09.14 | INCORPORATED DEO 9097 | |

DETAIL A
SCALE 5:24



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C-Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries